

**YILSA®**

YILDIZ ENDÜSTRİYEL ARAŞTIRMA MERKEZİ

MACHINE CATALOGUE

CODE: TP

Transfer Press

Hydraulic Punching, Cutting and Bending Press with Robot Transfer



A hydraulic transfer press that combines punching, cutting and bending stations in one frame and moves the part with a 2-axis linear robot, producing standard and heavy-duty wall bracket top parts and tray hanger profiles in all lengths from 100 to 600 mm with a single die.

100 – 600 mm

PRODUCT LENGTH

5 – 6 parts/min

PRODUCTION RATE

Up to 1.5 mm

SHEET THICKNESS

5.5 kW

HYDRAULIC MOTOR

01 Overview

The transfer press is a fully automatic hydraulic press that combines punching, cutting and bending units in one main frame and moves the part between stations by robot. It is a multi-purpose machine designed for series production of product groups in different lengths.

- ✓ Standard and heavy-duty wall bracket top parts and tray hanger profiles for threaded-rod ceiling systems, on one machine
- ✓ All lengths from 100 to 600 mm from one coil width and one die set
- ✓ Length changes via a digital recipe on the screen, with no mechanical or electrical adjustment
- ✓ Automatic transfer between stations with a position-controlled 2-axis linear robot with a rotating head
- ✓ No need for a separate die set for each length or for coils of different widths in stock
- ✓ Additional punching/cutting dies allow other sheet parts such as tray connectors to be produced
- ✓ Fully automatic operation: one supervisor is enough, and the operator can look after other lines at the same time

02 Technical Overview

Brackets in Many Lengths from a Single Die & Robot Transfer

Products: Bracket Top Parts & Tray Hanger Profile

The machine makes three products: the **standard-duty wall bracket top part**, the **heavy-duty wall bracket top part** and the **tray hanger profile** used in threaded-rod ceiling hanger systems. The base plate shown in grey in the images is not made on the transfer press; only the top part of the bracket is made on the press.

Dies made for each product's own dimensions allow bracket top parts and tray hanger profiles to be produced in different lengths.

Products: Standard Bracket Top Part | Heavy-Duty Bracket Top Part | Tray Hanger Profile

All Lengths from 100 to 600 mm with One Coil and One Die

The machine produces wall bracket top parts and hanger profiles in all lengths **from 100 mm to 600 mm**. All lengths are made from **a single coil width** and **a single die set**.

Length changes are made on the screen with a **digital recipe**; no mechanical or electrical adjustment or die change is needed. This removes the investment in a separate die for each length and the need to stock coils of different widths.

Length: 100–600 mm | One Coil Width | One Die Set



Punching, Cutting, Bending & 2-Axis Robot Transfer

Sheet from the straightener feeder is first **punched**, then **cut** to the required length and **bent** into its final shape. The part is moved automatically between stations by a **position-controlled 2-axis linear robot with a rotating head**.

The hydraulic unit runs on a **5.5 kW AC motor**; the cutting and punching dies are made of **1.2379 Böhler steel at 60 HRC**. With additional punching/cutting dies, other sheet parts such as **tray connectors** can also be produced.

Hydraulics: 5.5 kW | Dies: 1.2379, 60 HRC | Transfer: 2-Axis Robot

Fully Automatic, Compact Production with a Single Operator

The machine produces **5–6 parts** per minute without human intervention and is controlled from a **PLC + HMI touch screen**; any faults are signalled by warning lights. **One supervisor** is enough to run it; because it works automatically, the operator can look after other production lines at the same time.

The compact frame of about **2.5 × 1.0 × 1.4 m** and **1,800 kg** takes up little floor space. The bracket top parts made on the transfer press are joined to the base parts by MIG welding to complete the wall bracket.

Speed: 5–6 parts/min | Size: 2.5 × 1.0 × 1.4 m | Operator: 1 person

03 Technical Specifications

Production Capacity

Products	Standard and heavy-duty wall bracket top part, tray hanger profile
Product Length	100 – 600 mm
Production Rate	5 – 6 parts/min
Sheet Thickness	Up to 1.5 mm
Material	Galvanised or mild steel coil sheet

Drive, Dies & Control

Hydraulic Motor	5.5 kW AC
Die Steel	1.2379 (Böhler), 60 HRC
Part Transfer	2-axis linear robot, rotating head
Control	PLC + HMI touch screen, warning lights

Machine Dimensions

Size (L × W × H)	2,5 × 1,0 × 1,4 m
Weight	Approx. 1,800 kg
Operator	1 supervisor

04 Products

Wall bracket top part



Heavy-duty wall bracket top part



Tray hanger profile

The grey base plates are not made on the transfer press; the bracket top part is joined to the base by MIG welding.



Wall bracket top parts in different lengths, made with the same die

Length changes are fully digital: a recipe is selected on the screen, with no mechanical or electrical adjustment. No separate automatic die is needed for each length, and only one coil width is stocked.

05 Images



Transfer press in the workshop — 2-axis linear robot rail, cable chain and hydraulic press frame, real photo

06 In the Production Line

Transfer Press Line

www.yilsa.com.tr/en/transfer-press-line



01

Uncoiler



02

Straightener Feeder



03

Transfer Press

The Transfer Press Line is a monolithic system in which the uncoiler, straightening/feeding, punching, cutting and bending units are combined automatically on a single main frame. Parts are moved between stations by a 2-axis linear robot. Standard and heavy-duty wall bracket top parts in different lengths from 100 mm to 600 mm, and the tray hanger profiles used in threaded-rod ceiling systems, are produced from a single coil width and a single die set — just by changing the recipe on the screen. Any faults are signalled by warning lights.



07 Service and Support

Acceptance test

Before delivery, the machine is tested at the YILSA plant under the buyer's supervision with test material supplied by the buyer; it is delivered once it produces the specified product.

Installation and training

Training takes 1 day at our plant in Denizli, with hands-on installation, operation and maintenance. Thanks to its compact, single-body (monolithic) design, the machine is easily installed and commissioned at the buyer's own plant.

Warranty

Mechanical parts carry a 1-year warranty, excluding misuse. Dies and blades are wear parts and are not covered by the warranty.

Spare dies and drawings

Heat-treatment and material certificates are supplied for the dies. Spare dies are made for a fee; die drawings are shared on request.

Technical support

Technical support is provided, with on-site service when needed. Travel and accommodation costs for on-site service are paid by the buyer.

Compliance and delivery

CE marked; designed in line with Machinery Directive 2006/42/EC, EN ISO 12100:2010 and EN 60204-1:2018; 100% made in Türkiye. Delivery time is stated in the quotation, depending on the configuration.

Raw material must meet the specifications given by YILSA. The values in this catalogue are for standard configurations; machines can be adapted to your product drawing and raw material.



Machine and line solutions built for your production

Since 1992 in Denizli, Türkiye, we have been designing and building Rotary Punch technology, cable tray systems, wheel weight lines and wire processing machines. Share your product drawing and raw material, and we will prepare a configuration and quotation for you.

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100% MADE IN TÜRKİYE

PATENTED ROTARY PUNCH

PLC/HMI CONTROL

Yıldız Endüstriyel Araştırma Merkezi San. ve Tic. Ltd. Şti. · Catalogue no. YILSA-KAT-TP · October 2026. Values are for standard configurations; machines can be adapted to your product and raw material.